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Ryan, Andrew; 1284 Kiowa, Lyons, CO 80540 (US).
BLAKESLEE, Bruce, Lynn; 5101 Flora St., Golden, CO
80403 (US).

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(74) Agent: **BERGER, Derek, J.**; Seagate Technology LLC,
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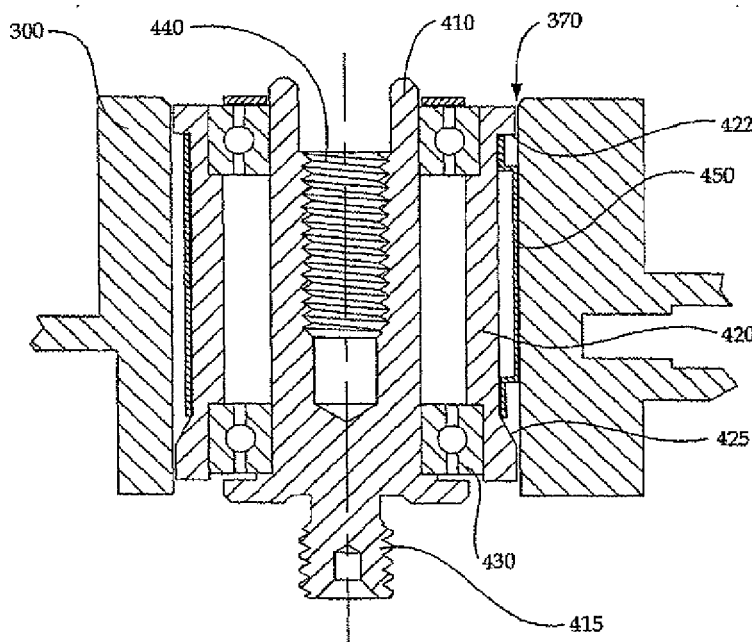
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(71) Applicant: **SEAGATE TECHNOLOGY LLC** [US/US];
920 Disc Drive, Scotts Valley, CA 95066 (US).

(72) Inventors: **BARINA, Jeffrey, Gerard**; 4919 South
County Road 23, Loveland, CO 80537 (US). **SIEVERS,**

For two-letter codes and other abbreviations, refer to the "Guid-
ance Notes on Codes and Abbreviations" appearing at the begin-
ning of each regular issue of the PCT Gazette.

(54) Title: INCREASED SLIP FORCE PIVOT BEARING



(57) Abstract: The sleeve of an actuator bearing cartridge is provided with an inclined surface on its outer surface. A tolerance ring is placed around the sleeve, and the cartridge and ring are then press-fit into the actuator bore together. Axial slippage of the ring and actuator relative to the cartridge is prevented as the ring is effectively wedged between the inclined surface and the inner surface of the actuator bore.



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INCREASED SLIP FORCE PIVOT BEARING

Cross Reference to Related Applications

This application claims the benefit of United States Provisional Application
5 Number 60/324,120, filed September 20, 2001.

Field of the Invention

This invention relates generally to the field of hard disc drive data storage
devices, and more particularly, but not by way of limitation, to rotational movement
10 of disc drive actuators.

Background of the Invention

Disc drives of the type known as "Winchester" disc drives, or hard disc
drives, are well known in the industry. Such disc drives magnetically record digital
15 data on a plurality of circular, concentric data tracks on the surfaces of one or more
rigid discs. The discs are typically mounted for rotation on the hub of a brushless
DC spindle motor. In disc drives of the current generation, the spindle motor rotates
the discs at speeds of up to 15,000 RPM.

Data are recorded to and retrieved from the discs by an array of vertically
20 aligned read/write head assemblies, or heads, which are controllably moved from
track to track by an actuator assembly. The read/write head assemblies typically
consist of an electromagnetic transducer carried on an air bearing slider. This slider

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acts in a cooperative pneumatic relationship with a thin layer of air dragged along by the spinning discs to fly the head assembly in a closely spaced relationship to the disc surface. In order to maintain the proper flying relationship between the head assemblies and the discs, the head assemblies are attached to and supported by flexures attached to the actuator.

The actuator assembly used to move the heads from track to track has assumed many forms historically, with most disc drives of the current generation incorporating an actuator of the type referred to as a rotary voice coil actuator. A typical rotary voice coil actuator consists of a pivot shaft fixedly attached to the disc drive housing base member closely adjacent the outer diameter of the discs. The pivot shaft is mounted such that its central axis is normal to the plane of rotation of the discs. The actuator is mounted to the pivot shaft by precision ball bearing assemblies within a bearing housing. The actuator supports a flat coil which is suspended in the magnetic field of an array of permanent magnets, which are fixedly mounted to the disc drive housing base member. These magnets are typically mounted to pole pieces which are held in positions vertically spaced from another by spacers at each of their ends.

On the side of the actuator bearing housing opposite to the coil, the actuator assembly typically includes a plurality of vertically aligned, radially extending actuator head mounting arms, to which the head suspensions mentioned above are mounted. These actuator arms extend between the discs, where they support the head assemblies at their desired positions adjacent the disc surfaces. When

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controlled DC current is applied to the coil, a magnetic field is formed surrounding the coil which interacts with the magnetic field of the permanent magnets to rotate the actuator bearing housing, with the attached head suspensions and head assemblies, in accordance with the well-known Lorentz relationship. As the actuator bearing housing rotates, the heads are moved generally radially across the data tracks of the discs along an arcuate path.

As explained above, the actuator assembly typically includes an actuator body that pivots about a pivot mechanism disposed in a medial portion thereof. The function of the pivot mechanism is crucial in meeting performance requirements associated with the positioning of the actuator assembly. A typical pivot mechanism has two ball bearings with a stationary shaft attached to an inner race and a sleeve attached to an outer race. The sleeve is also secured within a bore in the actuator body. The stationary shaft typically is attached to the base deck and the top cover of the disc drive.

Bearing cartridges have been mounted within actuator bores in a variety of ways. Some have simply press-fit the cartridge into the bore; others have formed the bore of the actuator of plastic in order to facilitate such press-fitting. Still others have provided screws in the actuator body which extend into the bore, either to serve as set screws pressing against the cartridge sleeve or to engage threads in the cartridge sleeve so as to pull the cartridge into tight contact with the bore. However, all of these methods present additional problems: simple press-fitting risks damage to both the bore and cartridge; plastic bores are subject to thermal expansion and

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contraction, as well as fatigue; and providing screws and their bores requires additional parts, manufacturing steps and costs.

One solution to these problems has been to provide a groove in the outer surface of the sleeve, and then positioning a tolerance ring within the groove. The tolerance ring is typically made of a compressible yet resilient piece of material such as a corrugated steel sheet. The bearing cartridge and tolerance ring assembly is then press-fit into the bore of the actuator body, the tolerance ring holding the cartridge in place within the bore while yielding enough so that neither the cartridge nor the bore is damaged as a result of the press-fitting operation. This method has proven largely satisfactory.

However, even this arrangement raises other problems. For example, the bearing and tolerance ring are typically made of steel because of its high strength, while the actuator bore's inner surface is often made of aluminum because of its relatively low weight and cost. Aluminum is a much softer material than steel, so when the bearing cartridge and tolerance ring are pressed into the actuator bore, the steel corrugations tend to "bite" into the soft aluminum bore by mildly deforming the aluminum, resulting in a high level of friction between the ring and bore. Where the bearing cartridge is made of steel, however, there is little between the cartridge and ring to create friction between them. This greatly raises the risk of axial slippage between the bearing cartridge and the tolerance ring during shock events. In fact, tests have borne this out, indicating that slip between a steel ring and steel cartridge occurs at about a mere 20% of the force required to cause slip between the ring and

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an aluminum actuator bore.

In order to prevent slip between the cartridge and tolerance ring, then, it has generally been necessary to increase assembly forces to a very high degree. The result has been that slip between the cartridge and tolerance ring has been
5 eliminated, by creating a tighter fit between the bore, ring and cartridge. The extremely tight fit has the added effects of making assembly more problematic, raising the risk of cartridge or actuator damage, and also results in frictional forces between the ring and bore far in excess of what is necessary to prevent slip between them.

10 What the prior art has been lacking is a bearing cartridge mounting arrangement which is easily assembled but which is resistant to slip when subject to axial forces.

Summary of the Invention

15 The present invention is directed to an easily assembled bearing cartridge mounting arrangement. Prior to installing a bearing cartridge in an actuator bore, a tolerance ring is placed around the cartridge. The outer surface of the cartridge sleeve is provided with an inclined surface abutted by one end of the tolerance ring. The cartridge and ring are then press-fit into the actuator bore together. Axial
20 movement of the cartridge is thereby minimized, eliminating the need to otherwise increase compressive forces between the ring and the bore and bearing. Additional features and benefits will become apparent upon a review of the attached figures

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and the accompanying description.

Brief Description of the Drawings

FIG. 1 shows an exploded view of a disc drive incorporating the bearing
5 mounting assembly of the present invention.

FIG. 2 shows an exploded view of an actuator incorporating the bearing
mounting assembly of the present invention.

FIG. 3 depicts a cross-sectional view of a bearing mounted within an actuator.

FIG. 4 shows a cross-sectional view of a tolerance ring sandwiched between a
10 bearing cartridge and actuator bore.

FIG. 5 shows an enlarged view of the interface between the tolerance ring and
the bearing cartridge as shown in FIG. 4.

Detailed Description of the Invention

15 Turning now to the drawings and specifically to FIG. 1, shown is an exploded
view of an example of a disc drive 100 in which the present invention is particularly
useful. The disc drive 100 includes a deck 110 to which all other components are
directly or indirectly mounted and a top cover 120 which, together with the deck
110, forms a disc drive housing which encloses delicate internal components and
20 isolates these components from external contaminants.

The disc drive 100 includes a plurality of discs 200 which are mounted for
rotation on a spindle motor (not shown). The discs 200 include on their surfaces a

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plurality of circular, concentric data tracks **210** on which data are recorded via an array of vertically aligned head assemblies (one of which is shown at **310**). The head assemblies **310** are supported by flexures **320**, which are attached to arm portions of actuator **300**. The actuator **300** is mounted to a bearing assembly **400** which includes
5 a stationary pivot shaft **410** about which the actuator **300** rotates.

Power to drive the actuator **300** about the pivot shaft **410** is provided by a voice coil motor (VCM). The VCM consists of a coil **330** which is supported by the actuator **300** within the magnetic field of a permanent magnet assembly having spaced upper and lower magnets **340**. The magnets **340** are mounted to spaced pole
10 pieces **350** which are fixed to the deck **110** and are further spaced from one another by spacers **360**. Electronic circuitry is provided on a printed circuit board (PCB, not shown) mounted to the underside of the deck **110**. Control signals to drive the VCM are carried between the PCB and the moving actuator **300** via a flexible printed circuit cable (PCC) **380**, which also transmits data signals to and from the heads **310**.

15 FIG. 2 shows a partially exploded, perspective view of an actuator **300** incorporating the bearing assembly of the present invention. The actuator **300** has a bore **370** formed therethrough which receivingly engages a bearing assembly. The bearing assembly is shown to include a bearing cartridge **400** and a tolerance ring **450** compressingly interposed between the bearing cartridge **400** and the bore **370** to
20 retain the bearing cartridge **400** within the bore **370**. The cartridge **400** and the tolerance ring **450** are installed by first placing the tolerance ring **450** around the cartridge **400**, and then axially inserting the cartridge-ring assembly into the actuator

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bore 300.

FIG. 3 shows a cross-sectional view of the actuator 300 with the bearing cartridge 400 and the tolerance ring 450 installed in actuator bore 370. The cartridge 400 has a stationary pivot shaft 410 which has a threaded projection 415 at its lower end for secure mounting to the floor of deck 110. The cartridge 400 also includes an outer sleeve 420 connected to the shaft 410 at upper and lower ends thereof by a pair of ball bearings 430. The stationary shaft 410 may also include an upper threaded opening 440 to receive a fastener (not shown) for attachment of the stationary shaft 410 to the top cover 120. It will be readily understood that the shaft 410 could be attached to the deck 110 and cover 120 by other means than those disclosed here without departing from the spirit of the present invention. In this manner it will be understood that the stationary shaft 410 is rigidly supported and the sleeve 420 is free to rotate about the stationary shaft 410. The sleeve 420 of the bearing cartridge 400 forms an upper shoulder 422, a lower shoulder 425, and a groove of a reduced diameter between the shoulders 422,425. The tolerance ring 450 is seated in the groove before the bearing cartridge 400 is placed into the bore 370. As can be clearly seen in FIG. 3, the upper shoulder 422 of sleeve 420 extends horizontally, at a right angle to the vertical surface of the groove in the sleeve 420. It is formed this way such that the when the cartridge 400 is forced downwardly into the bore 370, the upper end of the ring 450 abuts the shoulder 422 and is forced into the bore against the frictional forces created between the ring 450 and the bore 370.

As can be seen in FIG. 2, the tolerance ring 450 is typically a split ring

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member which forms a cylindrical inner surface 460 and a cylindrical outer surface 470, with a plurality of projecting corrugations 480 forming a corrugated surface on the outer surface 470. Such tolerance rings are well-known, for a variety of purposes, and examples of such rings are those manufactured by USA Tolerance
5 Ring.

It will be understood from FIG. 4 that the tolerance ring 450 is sandwiched between the groove of the sleeve 420 and the surface of the bore 370 of the actuator 300. The sleeve 420 and tolerance ring 450 combine to provide an effective outer diameter that is greater than the diameter of bore 370. As such, the sleeve 420 and
10 tolerance ring 450 combination can be press fit into the bore 370. The press-fit compresses the corrugations 480 as shown in FIG. 4 where the broken lines denote the shape of the corrugations 480 before insertion into the bore 370. The compression imparted to the corrugations 480 of the tolerance ring 450 creates sufficient frictional resistance to retain the tolerance ring 450 within the bore 370,
15 preventing displacement of the tolerance ring 450 relative to the actuator both axially and rotationally.

The frictional resistance between the tolerance ring 450 and the actuator bore 370 is typically greater than that between the ring 450 and cartridge sleeve 420. This is primarily because the corrugations 480 of the ring 450, which are made of steel,
20 actually mildly deform the softer aluminum from which the actuator bore 370 is formed. The bearing cartridge sleeve 420, however, is typically made of steel, and much less frictional resistance is created between the machined surface of the sleeve

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420 and the inner surface 460 of the tolerance ring 450. It follows that even when the tolerance ring 450 is securely axially located within the bore 370, slippage may occur nonetheless between the cartridge 400 and the tolerance ring 450 if measures are not taken to prevent it.

5 As explained above with respect to FIG. 3, the tolerance ring 450 abuts against upper shoulder 422 during assembly, which forces the ring 450 into the bore 370 along with the cartridge 400. After assembly, this upper shoulder 422 also prevents the cartridge 400 from moving downwardly relative to the sleeve during a shock event. In the past, cartridges have typically been provided with a similar lower
10 shoulder in order to prevent upward movement of the cartridge 400 relative to the ring 450. In fact, if it were possible to make the height of the ring 450 precisely equal to that of the groove, the cartridge 400 would be securely located between the shoulders and axial movement of the cartridge 400 would not be possible. In reality, however, it has been found to be impractical to attempt to manufacture the rings 450
15 with such precision. For this reason, they are generally designed to be slightly shorter than the height of the groove of the sleeve 420 to ensure that they may easily be placed within the groove during the assembly process. Upon assembly, there has been clearance between the lower edge of the ring 450 and the lower shoulder on the order of a few thousands of an inch. It is within this tolerance that the cartridge 400
20 may slide within the ring 450 when subject to shock.

 In a preferred embodiment of the present invention, however, the lower shoulder 425 is configured so as to be angled relative to the vertical surface of the

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groove in the sleeve 420 as illustrated in FIG. 5. The inclined surface 425 is formed as a chamfer extending about the circumference of the cartridge 400. The inclined surface 425 is positioned such that when the upper edge of the ring 450 abuts the upper shoulder 422, the lower edge slightly overlies the uppermost portion of the inclined surface 425. This eliminates the tolerance problem associated with a square lower shoulder discussed above, as the cartridge 400 and the ring 450 may easily be pressed into the bore 370, even though the height of the ring 450 is greater than the height of the vertical surface between upper and lower shoulders 422, 425.

Moreover, once assembled, the inclined surface 425 assists in preventing axial movement of the cartridge 400 relative to the tolerance ring 450. As explained above, the upper edge of the ring 450 abuts the upper shoulder 422 of the sleeve 420 when the cartridge 400 and ring 450 are initially inserted into the actuator bore 370, thereby preventing the actuator 300 from moving upwardly relative to the cartridge 400. When subject to a shock event tending to exert a downwardly directed force on the actuator 300, any downward movement of the ring 450 will cause it to be forced radially outward by the inclined surface 425 toward the surface of the actuator bore 370. Because the ring 450 is already in contact with the surface of the bore 370, however, any expansion of the ring will be resisted, thereby further resisting movement of the ring 450 relative to the cartridge 400. The lower edge of the ring 450 is effectively "wedged" between the inclined surface 425 of the cartridge 400 and the inner surface of the bore 370.

The precise angle at which the inclined surface extends relative to horizontal,

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as illustrated at 427 in FIG. 5, will vary depending upon design requirements and limitations which will vary from drive to drive. In one embodiment, angle 427 is about 73 degrees from horizontal. At this gentle slope, slight variances in the length of ring 450 are easily accommodated without forcing the ring 450 too far outward so as to interfere when the cartridge 400 and ring 450 are pressed into the bore 370.

In another embodiment, the angle 427 is about 45 degrees from horizontal. Once the cartridge 400 and ring 450 are installed, this steeper angle resists axial movement of the actuator 300 and ring 450 more effectively than the 73 degree slope discussed above, as the outer surface of the ring 450 will be forced outwardly more rapidly during a shock event. These embodiments are provided for example only; it should be clear that a variety of different angles could be effective in facilitating assembly while preventing slippage.

Of course, it should be understood that a bearing cartridge mounting arrangement may differ from the example described above without departing from the spirit of the claimed invention. For example, some bearing assemblies may be inserted into an actuator bore from below; in these cases, the inclined surface would preferably be located at the upper end of the sleeve, while the conventional horizontal shoulder would be positioned at the lower end of the sleeve.

Alternately stated, a first contemplated embodiment of the invention takes the form of an actuator mounting assembly having a bearing cartridge (such as 400) configured to be positioned in a bore (such as 370) within the actuator (such as 300). The cartridge (such as 400) includes a shaft (such as 410) having a substantially

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vertical axis and a generally cylindrical sleeve (such as 420) rotatable about the shaft (such as 410). The sleeve (such as 420) includes a first surface (such as 425) extending at an angle (such as 427) between vertical and horizontal. The assembly also includes a retention element (such as 450) configured to be positioned between
5 the sleeve (such as 420) and a surface of the bore (such as 370). The first surface (such as 425) is configured to contact the retention element (such as 450) so as to prevent relative movement between the sleeve (such as 420) and the retention element (such as 450). The retention element (such as 425) may be corrugated sheet substantially surrounding the cartridge (such as 400). The first surface (such as 425)
10 may take the form of a chamfer extending about the circumference of the sleeve (such as 420). The first surface (such as 425) may extend at an angle (such as 427) of about 73 degrees from horizontal. The sleeve (such as 420) may include a second substantially horizontally extending surface (such as 422) configured to contact the retention element (such as 450) so as to prevent relative movement between the
15 sleeve (such as 420) and the retention element (such as 450).

Alternately stated, a second contemplated embodiment of the invention takes the form of a disc drive (such as 100) having a housing (such as 110,120), a substantially horizontally extending actuator (such as 300) having a bore (such as 370) therein and a bearing cartridge (such as 400) fixed to the housing (such as
20 110,120) and positioned within the bore (such as 370). The cartridge (such as 400) has a substantially vertical axis of rotation. The drive (such as 100) further includes a resilient element (such as 450) positioned between the cartridge (such as 400) and a

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surface of the bore (such as 370). An element is associated with the cartridge (such as 400) having a surface (such as 425) extending at an angle (such as 427) between horizontal and vertical. The surface (such as 425) contacts the resilient element (such as 450) so as to prevent all axial movement of the actuator (such as 300) relative to the cartridge (such as 400). The resilient element (such as 450) may take the form of a tolerance ring. The surface (such as 425) may extend at an angle (such as 427) of about 45 degrees from horizontal. The resilient element (such as 450) may have upper and lower edges and the surface (such as 425) may contact one of the upper and lower sleeve edges.

From the foregoing, it is apparent that the present invention is particularly suited to provide the benefits described above. While particular embodiments of the invention have been described herein, modifications to the embodiments which fall within the envisioned scope of the invention may suggest themselves to one of skill in the art who reads this disclosure.

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We claim:

1. An actuator mounting assembly, comprising:

a bearing cartridge configured to be positioned in a bore within the actuator,

the cartridge comprising:

5 a shaft having a substantially vertical axis; and

a generally cylindrical sleeve rotatable about the shaft, the sleeve

further comprising a first surface extending at an angle between

vertical and horizontal; and

a retention element configured to be positioned between the sleeve and a

10 surface of the bore, the first surface being configured to contact the

retention element so as to prevent relative movement between the

sleeve and the retention element.

2. The mounting assembly of claim 1 in which the retention element comprising a

15 corrugated sheet substantially surrounding the cartridge.

3. The mounting assembly of claim 1 in which the first surface comprises a chamfer
extending about the circumference of the sleeve.

20 4. The mounting assembly of claim 1 in which the first surface extends at an angle of
about 73 degrees from horizontal.

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5. The mounting assembly of claim 1 in which the sleeve further comprises a second substantially horizontally extending surface, the second surface being configured to contact the retention element so as to prevent relative movement between the sleeve and the retention element.

5

6. A disc drive, comprising:

a housing;

a substantially horizontally extending actuator having a bore therein;

a bearing cartridge fixed to the housing and positioned within the bore, the

10

cartridge having a substantially vertical axis of rotation;

a resilient element positioned between the cartridge and a surface of the bore;

and

an element associated with the cartridge having a surface extending at an

angle between horizontal and vertical, the surface contacting the

15

resilient element so as to prevent all axial movement of the actuator

relative to the cartridge.

7. The disc drive of claim 6 in which the resilient element comprises a tolerance ring.

20

8. The disc drive of claim 6 in which the surface extends at an angle of about 45 degrees from horizontal.

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9. The disc drive of claim 6 in which the resilient element has upper and lower edges, the surface contacting one of the upper and lower sleeve edges.

10. A disc drive comprising:

- 5 a bearing cartridge;
an actuator connected to the cartridge so as to be rotatable about an axis; and
means for restricting axial movement of the actuator relative to the cartridge.

AMENDED CLAIMS

[received by the International Bureau on 30 October 2002 (30.10.02);
original claim 6 amended; remaining claims unchanged (1 page)]

5. The mounting assembly of claim 1 in which the sleeve further comprises a second substantially horizontally extending surface, the second surface being configured to contact the retention element so as to prevent relative movement between the sleeve and the retention element.
6. A disc drive, comprising:
- a housing;
 - a substantially horizontally extending actuator having a bore therein;
 - a bearing cartridge fixed to the housing and positioned within the bore, the cartridge having a substantially vertical axis of rotation;
 - a resilient element positioned between the cartridge and a surface of the bore;
 - and
 - an element associated with the cartridge having an inclined surface contacting the resilient element so as to prevent all axial movement of the actuator relative to the cartridge.
7. The disc drive of claim 6 in which the resilient element comprises a tolerance ring.
8. The disc drive of claim 6 in which the surface extends at an angle of about 45 degrees from horizontal.

STATEMENT UNDER ARTICLE 19 (1)

Claim 6 has been amended to make it clear that the surface of the cartridge which contacts the resilient element is inclined.

Claims 1-5 and 7-10 remain unchanged.

Claim 1 requires that the first surface be angled between vertical and horizontal and also configured to contact a retention element configured to be positioned between the sleeve and a surface of the actuator bore. U.S. Patent 6,163,441 to Wood et al. (hereinafter "Wood") shows only angled cartridge surfaces which are shown to contact outer bearing races in FIG. 3. These surfaces cannot reasonably be construed as showing "the first surface being configured to contact the retention element" as clearly required by claim 1. While U.S. Patent 5,999,373 to Allsup et al. (hereinafter "Allsup") shows angled surfaces such as those at 168, these also cannot reasonably be construed as contacting a retention element configured to be positioned between a sleeve and bore.

It is therefore respectfully submitted that claim 1 is novel and represents an inventive step over Wood and Allsup, alone and in combination.

Claims 2-5 and 11-13 depend from claim 1 and are similarly allowable over Wood.

Similarly, claim 6 requires that an inclined surface associated with cartridge be in contact with a resilient element. Again, it cannot be reasonably asserted that the inclined surfaces of either Wood or Allsup are capable of contacting a resilient element as required by claim 6.

It is therefore respectfully submitted that claim 6 is novel and represents an inventive step over Wood and Allsup, alone and in combination.

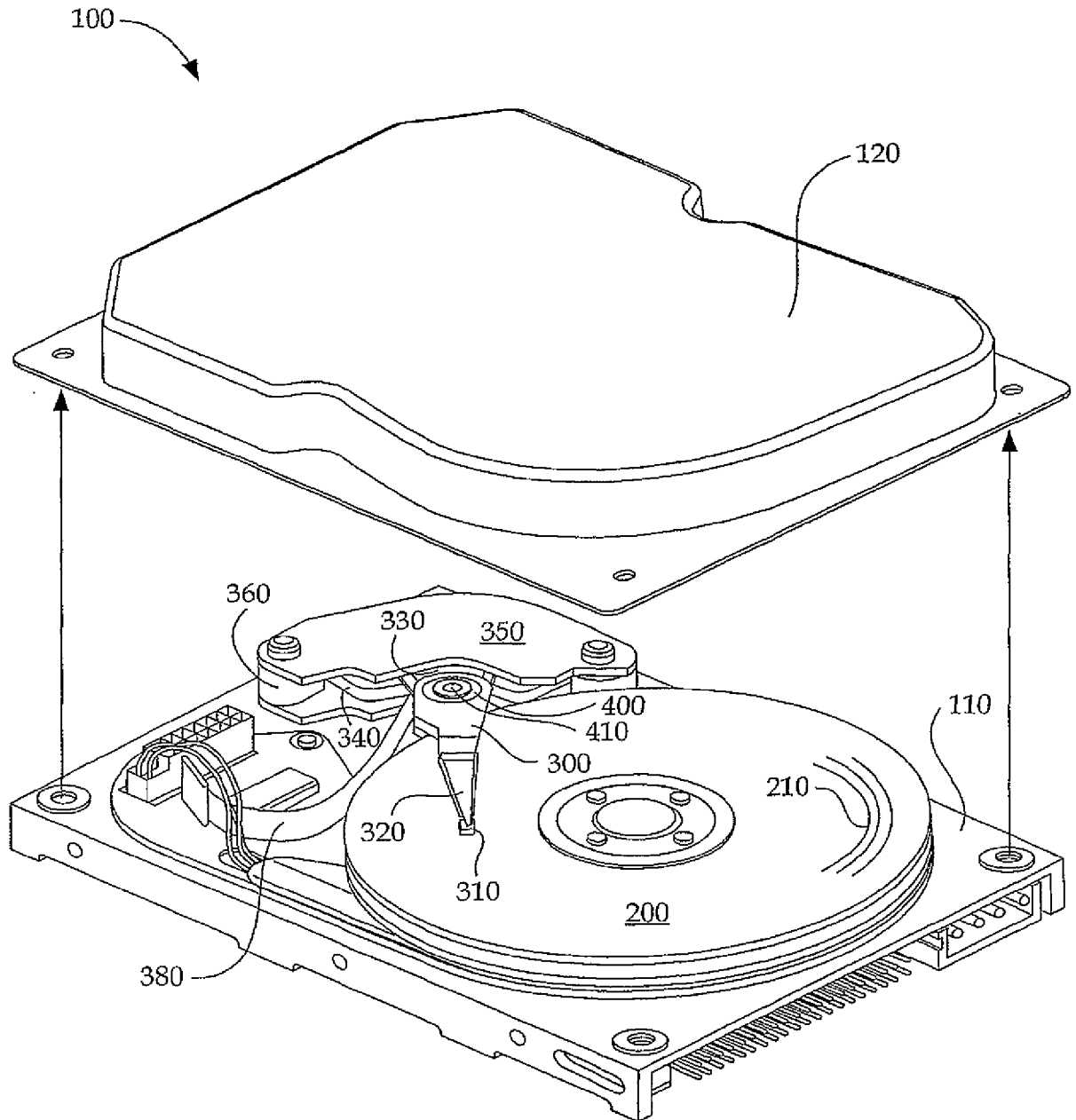


Fig. 1

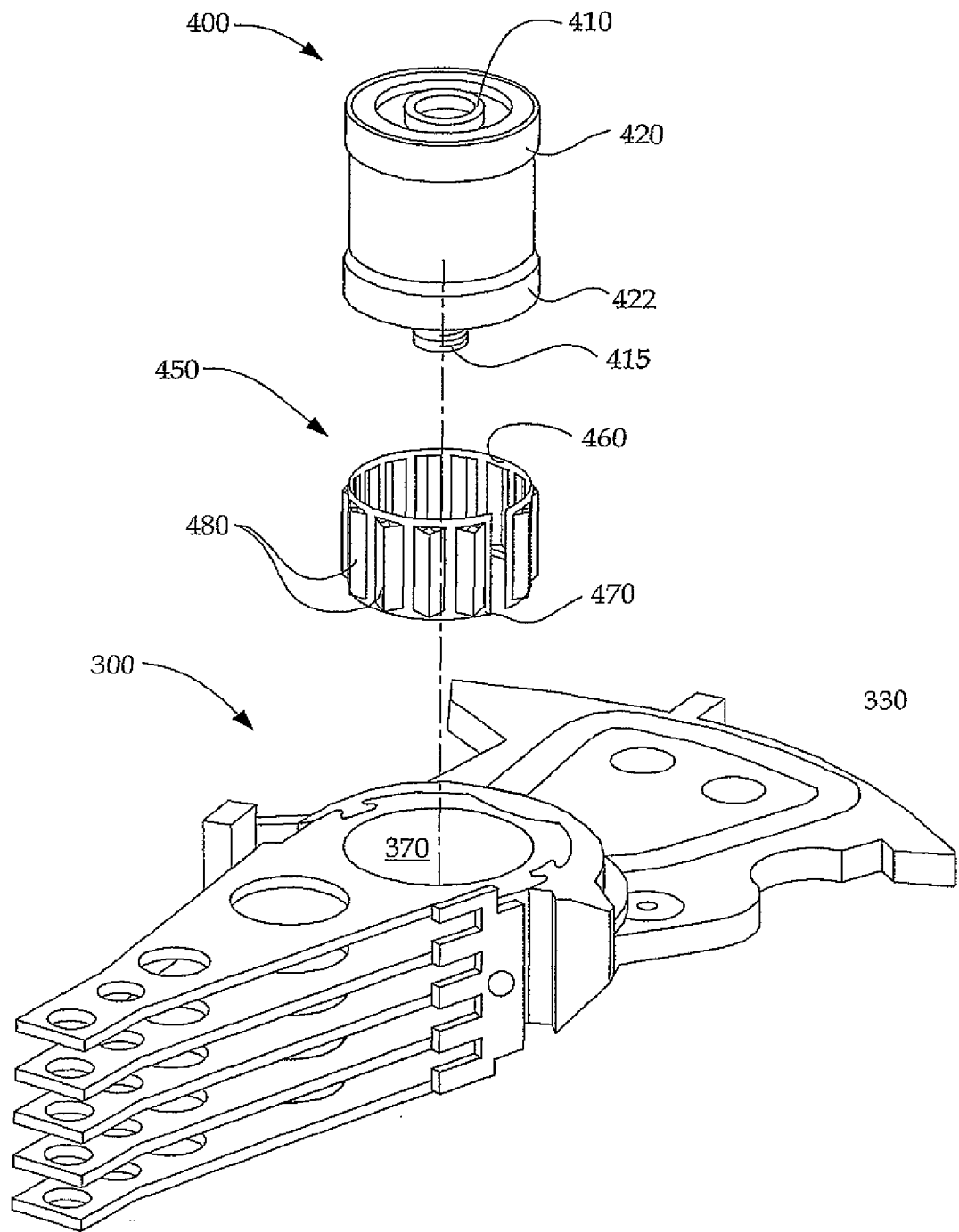


Fig. 2

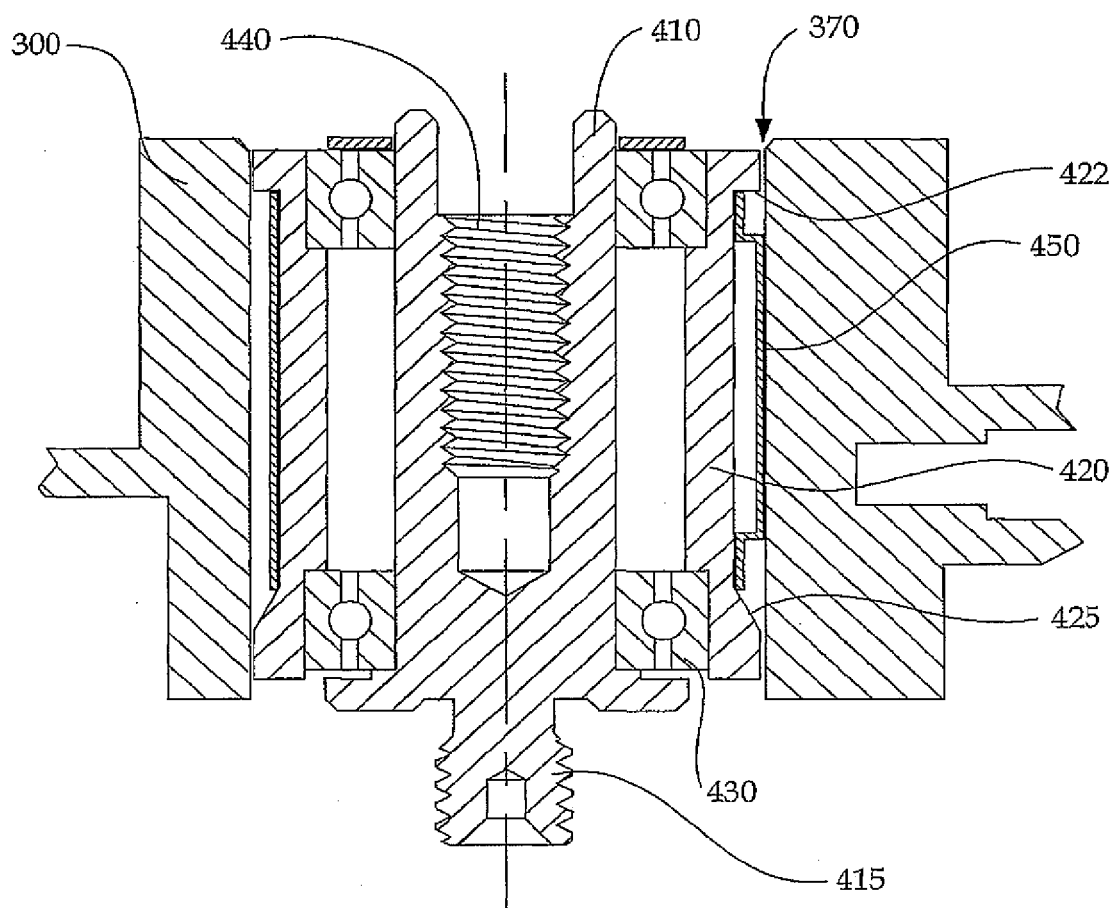


Fig. 3

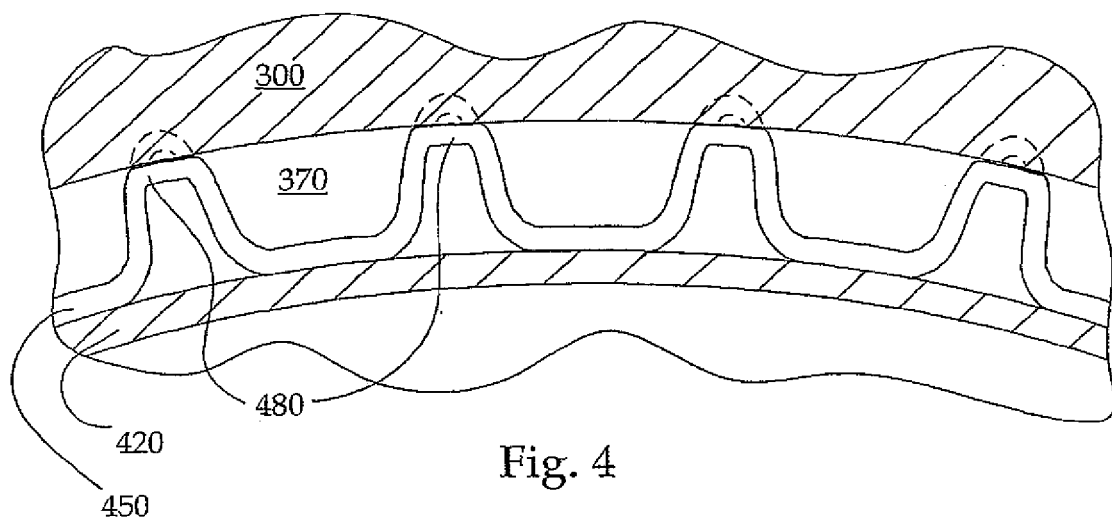


Fig. 4

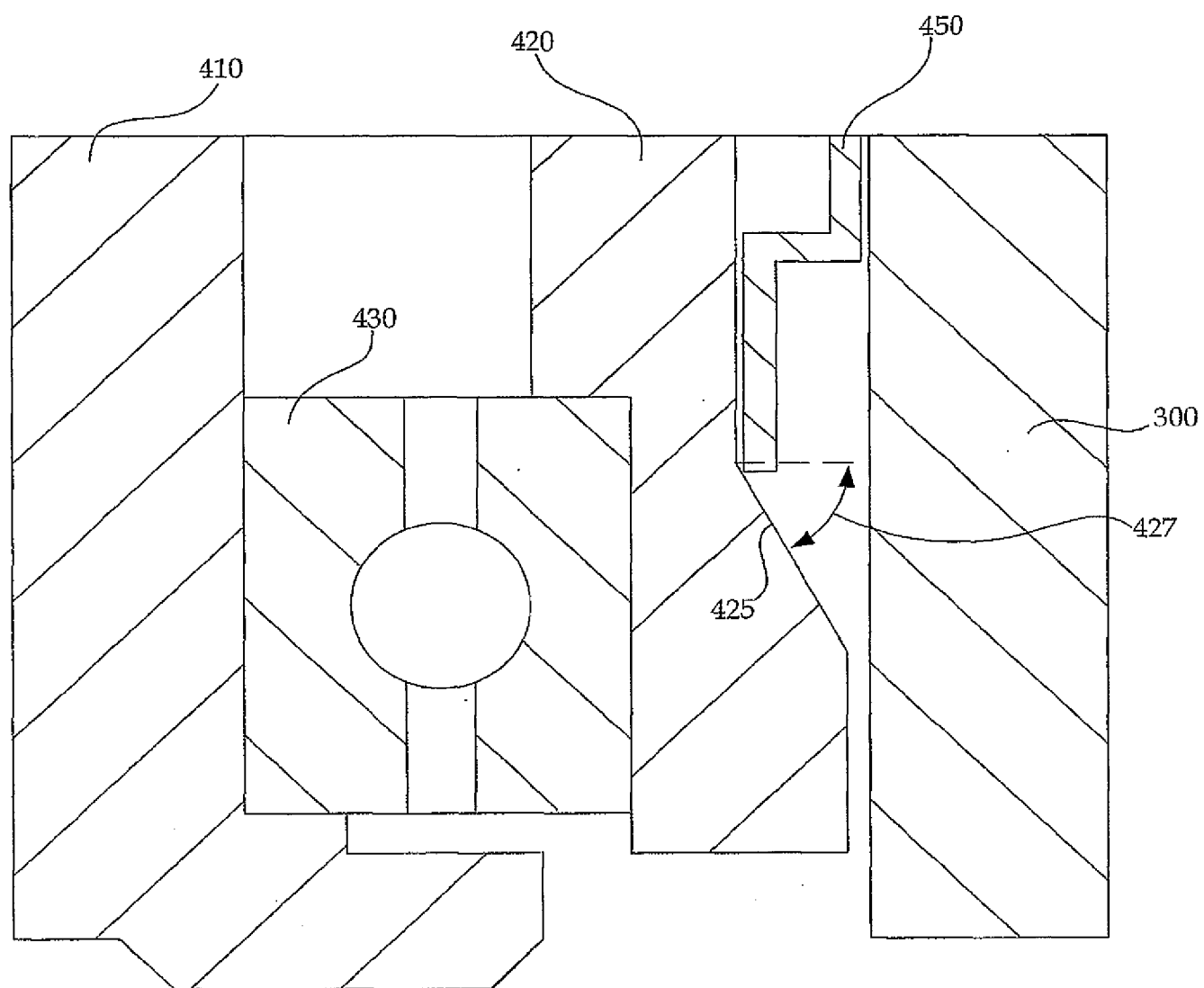


Fig. 5

INTERNATIONAL SEARCH REPORT

International Application No

PCT/US 01/44998

A. CLASSIFICATION OF SUBJECT MATTER
IPC 7 G11B5/48

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 G11B

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	US 6 163 441 A (MISSO NIGEL F ET AL) 19 December 2000 (2000-12-19) column 3, line 33 -column 4, line 67	1,6
Y	US 5 999 373 A (ANDRESS JEFFERY DON ET AL) 7 December 1999 (1999-12-07) column 4, line 41 -column 6, line 13	1,6
A	WO 01 59314 A (SEAGATE TECHNOLOGY LLC) 16 August 2001 (2001-08-16) page 8, line 16 -page 10, line 31; figure 8	1,6
A	US 3 776 653 A (BUZOGANY A) 4 December 1973 (1973-12-04) column 2, line 39 - line 67	1,6
-/-		

☒ Further documents are listed in the continuation of box C.☒ Patent family members are listed in annex.

* Special categories of cited documents :

- *A* document defining the general state of the art which is not considered to be of particular relevance
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X document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

Y document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.

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Date of the actual completion of the international search

23 August 2002

Date of mailing of the international search report

03/09/2002

Name and mailing address of the ISA

European Patent Office, P.B. 5618 Patentlaan 2
NL - 2280 HV Rijswijk
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl,
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INTERNATIONAL SEARCH REPORT

International Application No

PCT/US 01/44998

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	GB 1 036 181 A (ANGUS GEORGE CO LTD) 13 July 1966 (1966-07-13) the whole document	1,6

INTERNATIONAL SEARCH REPORT
Information on patent family members

International Application No

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